: 1/4 TURN FASTNER RAIL (BLACK)

Tuesday, 10/2/2007 10:44:04 AM

User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Job Number : 34944 **Estimate Number** : 10096

Al4: : 10/2/2007 S.O. No. : 1

: NC Prsht Rev. NA First Issue Previous Run

Type

: MACHINED PARTS

Drawing Number Project Number

Part Number

Drawing Name

Drawing Revision Material Due Date

: 11/10/2007

: D103858B

- D1038

: N/A

50 Um:

Each

Written By

P.O. Number

This Issue

Checked & Approved By Comment

: Est: E Reformat: Added label KJ/RF 03.05.02

Updated Packaging Procedures JLM Est Rev:F 06-08-16

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description:

1.0 DC



DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

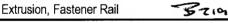
Create white labels and bag them

2.0 D2023 Extrusion, Fastener Rail



Comment: Qty.: 1.9030 f(s)/Unit

Total: 95.1500 f(s)



571907



BAND SAW



Comment: BAND SAW

Cut extrusion D2023 to length 21.81" (+0.06/-0.00)



4.0

3.0

HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1

1-Machine as per Folio and Dwg D1038-58



5.0

6.0

QC2

QC8

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SECOND CHECK



TO



Comment: SECOND CHECK





Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES										
DATE	STEP	PROCEDURE CHANGE					By Dat		Date Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
									(2)			
×'						·						
Part No	: -		PAR #:		Fault Category:		N	CR: Yes	No DQ	A:	Date:	

				4	QA: N/	Closed:	_ Date: _					
NCR:	-		WORK ORDER NON-CONFORMANCE (NCR)									
		Description of NC	Corrective Action Section B			Varification						
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Verification Section C	Approval Chief Eng	Approval QC Inspector				
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NOTE: Date & initial all entries

Tuesday, 10/2/2007 10:44:04 AM Date: User: · - Kim Johnston **Process Sheet** Drawing Name: 1/4 TURN FASTNER RAIL (BLACK) Customer: CU-DAR001 Dart Helicopters Services Job Number: 34944 Part Number: D103858B Job Number: Seq. #: Description: Machine Or Operation: SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1 7.0 Comment: SMALL & MEDIUM FAB RESOURCE 1 Deburr 8.0 QC5 Comment: INSPECT WORK TO CURRENT STEP 9.0 **OUTSIDE SERVICES-MACH** Comment: Sub-Contracting OUTSIDE SERVICES C207112114 Issue P/0: 5292 Black Anodize as per Dwg D1038 10.0 PACKAGING 1 PACKAGING RESOURCE #1 Comment: PACKAGING RESOURCE #1 Receive & Inspect For Transit Damage 11.0 Comment: Inspect Anodize. Place in foam to protect anodize SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1 12.0 Comment: SMALL & MEDIUM FAB RESOURCE 1 1-Stake .050 stainless steel wire per Dwg D1038-58 using DT8389 Batch: 1104298 X 50 2-Grind wire flush and deburr 3-Clean 13.0 QC5 INSPECT WORK TO CURRENT STEP Comment: INSPECT WORK TO CURRENT STEP

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES									
DATE STEP		•	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector				
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				4							

Part No:	PAR #:	Fault Category:	NCR: Yes No DQA:	Date: 081010
¥**			QA: N/C Closed:	Date:

NCR:			WORK ORDER NON-CONFORMANCE (NCR)									
	I	Description of NC		Corrective Action Section B	Verification	Approval	Approval					
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	QC Inspector				
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NOTE: Date & initial all entries

Date: User:

Tuesday, 10/2/2007 10:44:04 AM

Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 1/4 TURN FASTNER RAIL (BLACK)

Job Number: 34944

Seq. #:

Job Number:

Machine Or Operation:

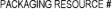
Description:

Part Number: D103858B

14.0

PACKAGING 1

PACKAGING RESOURCE #1





Comment: PACKAGING RESOURCE #1

1-Pack each fastener rail into a cardboard tube

2-Roll Part in foam .

3-Install red cap at each end and secure with tape.

4-Apply white labels to cardboard tubes

5-Identify and Stock

Location:_

15.0

QC21



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



le 08:01-09

Dart Ae	rospace	Ltd								
W/O:		3	WOI	RK ORDER CHANG	ES					
DATE	STEP	PROC	EDURE CHAN	GE		By Date		Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
				,						
		*								
Part No	:	PAR #:	_ Fault Catego	ory:	NCR	: Yes	No DQ/	\ :	_ Date: _	
				4		QA: N/	C Closed	i:	_ Date: _	
NCR:		W	ORK ORDE	R NON-CONFORMA	NCE	(NCR)			
		Description of NC	Corrective Action Section B				Verification	otion	Ammanal	A
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng		Sign & Date	Section		Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	34944
Description: 1/4" Turn Fastener	Part Number:	D1038-58B
Inspection Dwg: D1038-58B Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

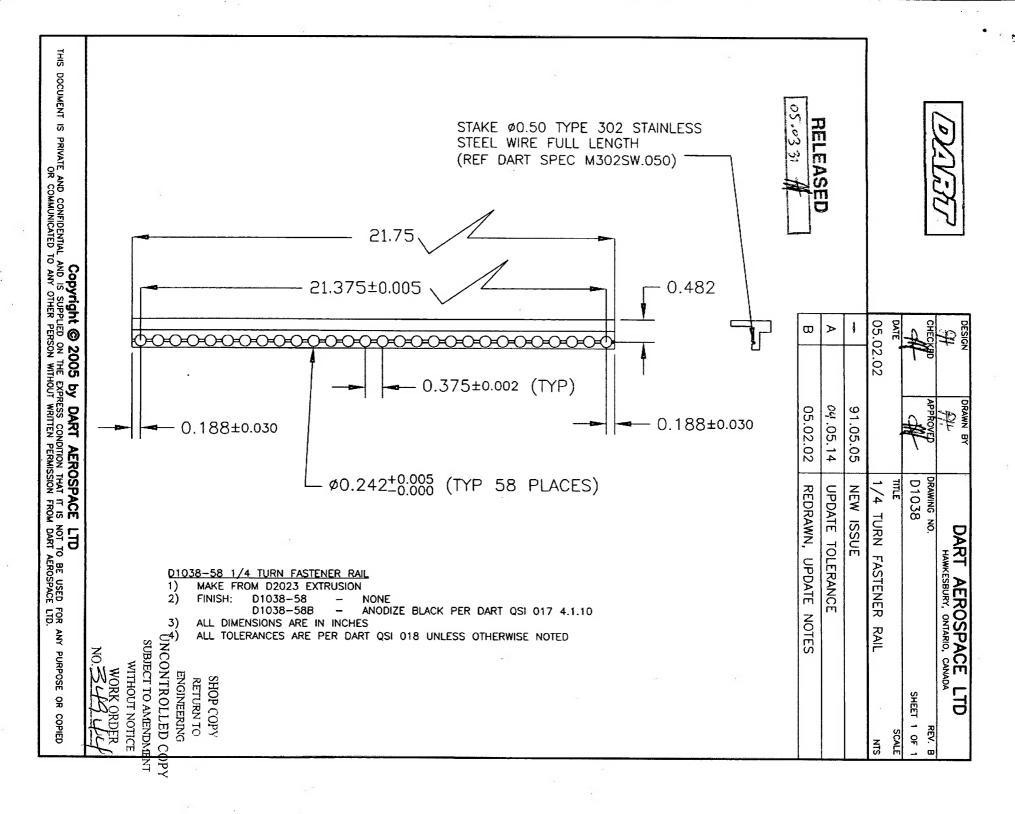
X First Article Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
21.750	+/-0.030	21.746				
0.375	+/-0.002	.375				
0.1875	+/-0.030	.185				
Ø0.242	+0.005/-0.000	. 243				
0.4825	+/-0.010	.4815				
		-4-		****		
-						
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				-10		

Measured by:	J.L	Audited by:	NE	Prototype Approval:	N/A
Date:	07/12/11	Date:	01.1211	Date:	N/A

Rev	Date	Change	Revised by	Approved
Α (05.02.16	New Issue	KJ/JLM	1
В (06.03.08	21.750 was 12.750, Dwg rev. changed	KJ/JLM	

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ANODISATION et PEINTURE TNM INC.

C. OF C



21 chemin de l'Aviation,Pointe Claire QC H9R 4Z2 Telephone: (514) 429-7777 Fax: (514) 429-5108 Certifié ISO 9001-2000 / AS9100 certified approuvé NADCAP approved

61066 21-Dec-2007

CLIENT / CUSTOMER:

DART AEROSPACE LTD.

1270 ABERDEEN STREET HAWKESBURY , ONTARIO K6A 1K7 CERTIFICATE OF COMPLIANCE CERTIFICAT DE CONFORMITE

PURCHASE ORDER/ NO. DE COMMANDE:

00005290



Nondestructive Testing

ITEM	COMMANDE ORDERED	EXPEO SHIPPE		R & DESCRIPTION	PART PROCESS & TREATMENT
1	50	50	D103858B	B34944	
					BLACK ANODIZE PER MIL-A-8625F1 TYPE II CLASS 2 ALL OVER
2	60	60	D103859B	B34968	The second secon
2					BLACK ANODIZE PER MIL-A-8625F1 TYPE II CLASS 2 ALL OVER
3	15	15	D32993	B35139	
					BLUE ANODIZE PER MIL-A-8625F1 TYPE II CLASS 2 ALL OVER
4	13	13	D32991	B35138	The state of the s
# 41W	in in the second of the second	C. BARNISAN VI BASI. July.			BLUE ANODIZE PER MIL-A-8625F1 TYPE II CLASS 2 ALL OVER

REQUIREMENTS HAVE BEEN IN ACCORDANCE WITH MD-INC P.R.I.D.E. MANUAL

Nous certifions que les pièces énumérées ont été traitées, testées et inspectées selon les spécifications mentionnées. Les cartes de travail ont été remplies et sont disponibles pour consultation, sur demande.

All parts are processed, tested, and inspected to the requirements of above specifications.

Travel cards have been filled and are available for viewing upon request.

NOTE: Painted Parts will be Fully Solvent Resistant after 7 (seven) Full Days of Air Curing at Ambient

Temperatures"

NOTE: Les pièces peintes seront completement résistantes au solvant après 7 (sept) jours complets de séchage à

ambiant.

Signature/Signed:

Directeur de la Qualité / Q.A. Manager

Page 1 of 1